



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 10:20:09 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 37929

Part Number: D2968041

Job Number:



Seq. #:

Machine Or Operation:

Description:

Issue P/O: 6092

C 208/04/08

Cad Plate per QQ-P-416F Class I Type II

(35)

Conformity sheet required

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

M 8/04/13 (35)

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT CAD PLATE

30 min

20/05/2008

9.0 POWDER COATING

POWDER COATING



M 107925

S.255 09.06

#1 401.8 F

#2 B37929 F

#3 D2968041 F

#4

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

\*\*\*DO NOT POWDER COAT THREADS\*\*\*

M 1 08/0

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M 1 08/05/20

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 464

M 1 08/05/21 (35)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/22 (35)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



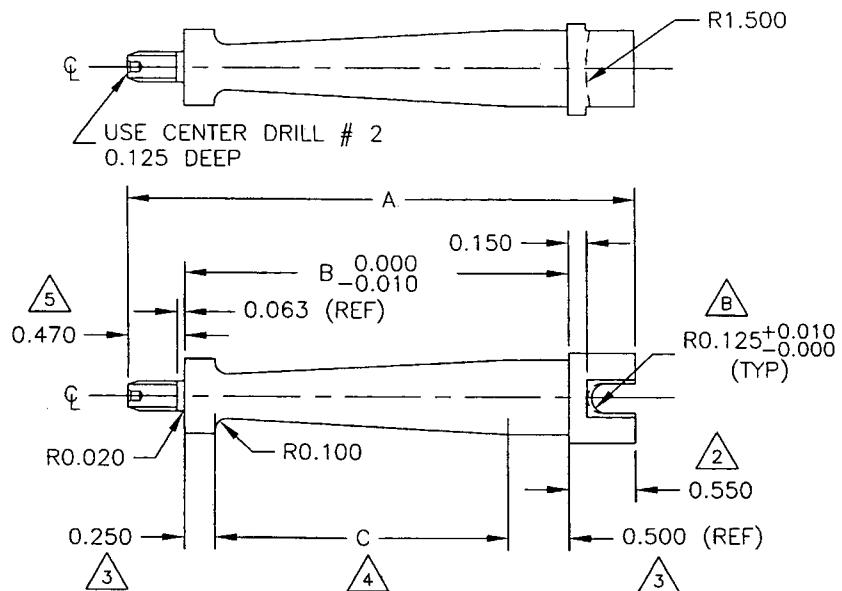
MF 08-05-21

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

### D2968-1 / -3 STEM

#### D2968-1 AND D2968-3 STEM:

- 1) MATERIAL: AISI 4130N ROUND BAR PER MIL-S-6758  
OR AMS 6348/6370/6528  
(REF DART SPEC M4130N-RX.XXX)
- 2)  $\varnothing 0.750$  O.D.
- 3)  $\varnothing 0.625$  O.D.
- 4) MACHINE UNIFORM TAPER FROM  $\varnothing 0.363$  O.D.  
TO  $\varnothing 0.625$  O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS  
UNLESS OTHERWISE INDICATED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED

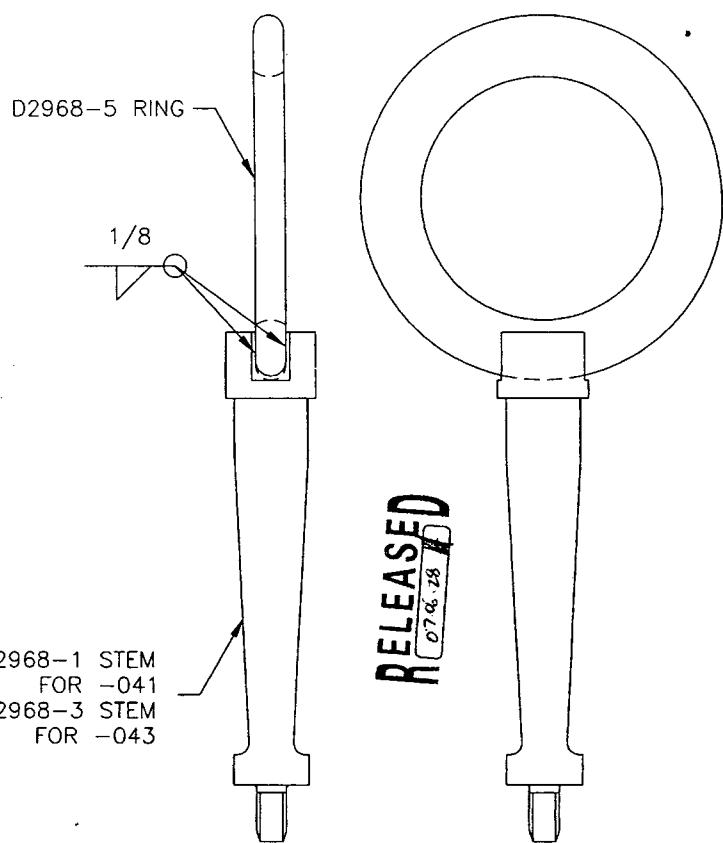
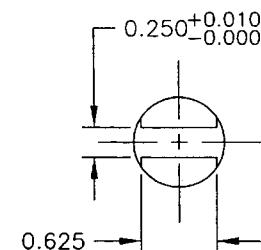
#### D2968-5 RING:

- 9) MATERIAL: AISI 4130N TUBING PER MIL-T-6736  
OR AMS 6360/6361/6362/6371/6373/6374  
(REF DART SPEC M4130NT3000W500)
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

*body*  
REVERSE SIDE  
UNLOCKING TO  
ENGRAVING TO  
RETURN TO  
STOCKY

R0.125+0.000  
-0.010

D2968-5 RING



#### D2968-041 AND D2968-043 TOW RING:

- 12) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 13) HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI
- 14) FINISH: CAD PLATE ENTIRE ASSEMBLY PER  
QQ-P-416F CLASS I TYPE II  
POWDER COAT WHITE (REF 4.3.5.2) PER DART  
QSI 005 4.3 (EXCEPT THREADS)

C	07.04.17	0.050 WAS 2.000, UPDATE NOTES
B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
<b>DART AEROSPACE LTD.</b> MARKSBURY, ONTARIO, CANADA		
DESIGN	DRAWN BY	
CHECKED	APPROVED	
DATE		TITLE
07.04.17		TOW RING

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OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

REV. C  
SHEET 1 OF 1  
1:1



**Placage  
Manco Domplex  
Electroplating**

Siège social / Head Office: Plan 1  
4660 Hickmore  
Ville St-Laurent, Québec  
H4T 1K2  
Fax: 514-355-8750

4670 Hickmore  
Ville St-Laurent, Québec  
Fax: 514-355-5991

Plan 2  
8001 Larrey  
Anjou, Québec  
Fax: 514-354-2937

**BON DE LIVRAISON  
PACKING SLIP**

Tél.: 514-355-7867 / 1-877-355 7867

E S  
X H 1941 December 17D  
P E  
E I P 1940 Aburatsu 57  
D I  
I T O Aburatsu 1940 57  
E T O  
O A

**AL CUNE RÉCLAMATION APRÈS 5 JOURS DE LA DATE DE LIVRAISON  
NO CLAIMS AFTER 5 DAYS FROM DATE OF DELIVERY**

# BON DE LIVRAISON  
**110636**

**MANCO**  
**DOMPLEX**

8695 Crescent 3  
Anjou (Québec) H1J 1J6  
Tel.: (514) 355-7867  
Fax: (514) 355-8750

ATTN: Chantal.

**CERTIFICAT DE CONFORMITÉ**  
**CERTIFICATE OF COMPLIANCE**

#4610

DART Aerospace LTO

Client / Customer

Rob692

Votre # de commande / Your purchase order #

D2968-011 B37929

# de la pièce / part #

R110636

Notre # de bon de livraison / Our packing slip #

Inspecteur / Inspector	Date, équipe / Date, shift	
Plaçage / Plating	Qof-416 F Class 1 Type 7	
Quantité totale / Total quantity	35	Quantité inspectée / Inspected quantity
Adhésion / Adhesion	Bonne	
Épaisseur / Thickness	L.C.D	H.C.D.
		Moy. / aver.
Coulisses, taches / Leach, spots	Non	Rugosité / Roughness
Quantité approuvée / Approved quantity	35	Quantité rejetée / Rejected quantity
	Commentaires / Comments	

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Sigéé au nom de  
Signed on behalf of

**MANCO**  
**DOMPLEX**

05/14/2008 WED 14:57 FAX 613 632 4443 DART HELICOPTER SERVICES → DAS - LINDA

4002/003

VAC AERO INT. INC. Fax: 905-865-8303

May 14 2008 02:45pm P002/003



**VAC AERO**  
INTERNATIONAL INC.

**RELEASE NOTE**

GST No.: R105468102

OAK 97585-1

HEAD OFFICE  
1371 SPEERS ROAD, OAKVILLE, ONTARIO  
CANADA L6L 2X5  
TEL: (905) 827-4171 FAX: (905) 827-7489

2009 WYECROFT ROAD, UNIT B  
OAKVILLE, ONTARIO  
CANADA L6L 6J4  
TEL: (905) 827-7377 FAX: (905) 827-1380

QUEBEC DIVISION  
7450 RUE VERTÉ STREET, ST. LAURENT, QUÉBEC  
CANADA H4S 1C5  
TEL: (514) 334-6240 FAX: (514) 334-6269

05/05/2008

MM/DD/YYYY

PAGE: 1

1DAR01

BILL TO: DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

SHIP TO: MANCO DOMPLEX  
4660 HICKMORE  
ST. LAURENT, QC

K6A 1K7

H4T 1K2

DATE SHIPPED	SHIP VIA	F.O.B.
05/02/2008	PUROLATOR #7684382	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
PO00006091 *		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D2968-04L	B37929 TOW RING	EA	35	35	
	Process Specifications: HEAT TREATED TO 125 KSI MIN. 100% HARDNESS TESTED PER ASTM E-18, HRC 26-32 *		Procedure: 4047		
	MATERIAL: 4130				
	P/S# 214596				
	+ AMENDMENT #1, MAY 14, 2008				

100% HARDNESS TESTED

35 PCS → 29/30 HRC

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO-INTERNATIONAL INC.

Authorized Q.C. Inspector



HEAT  
TREATING



VACUUM BRAZING • HEAT TREATING • SPECIAL PROCESSING • FURNACE EQUIPMENT  
TURBINE COMPONENT OVERHAUL • PLASMA AND OTHER COATINGS